



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3913-041
Job Sheet 183326



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/16/18

Job Tracking No:

Due Date: 10/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/26/18	10/26/18	0.00	0.00	Start Up Large Fab-5		DC 2018-10-16
100	Large Fab	1 pcs	10/26/18	10/26/18	0.00	10.00	Large Fab 1		2018-10-16
110	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC9		
120	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC5		
125	HandFinish	1 pcs	10/26/18	10/26/18	0.00	0.29	HandFinish2		2018-10-30
130	Powdercoat	1 pcs	10/26/18	10/26/18	0.00	0.93	Powdercoat2		2018-10-30
135	Packaging	1 pcs	10/26/18	10/26/18	0.00	0.00	Packaging1		11-11-01
140	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC3		11-11-01
150	HandFinish	1 pcs	10/26/18	10/26/18	0.00	0.50	HandFinish4		11-11-01
160	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC5		11-11-01
170	Packaging	1 pcs	10/26/18	10/26/18	0.00	0.00	Packaging3-2		21 NOV 0 1 2018
180	QC21-SA	1 Ea	10/26/18	10/26/18	0.00	0.00	QC21		21 NOV 0 1 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 188951 START: 2:00 OUT: 3:30 FINISH: 2:15.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5105222
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5112746
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5108592
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5112730
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5108295
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5116572
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5111464
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5114158
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5115309
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5110032
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5108326

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

5109707
 5108590
 5113926
 5113925
 5098052
 5093684
 5106952
 F86435
 5076007
 5094597
 5103666
 5108637

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	92	0
	D3913-1	1	7	0
	D3913-15	1	22	0
	D3913-3	1	8	0
	D3913-7	2	16	0
	D3913-9	1	12	0
	D3916-041	2	18	0
	D3916-5	3	30	0
	D4016-1	3	10	0
	D4017-7	3	58	0
	D4017-9	2	20	0
	D4020-11	2	35	0
	D4021-1	3	55	0
	D4034-041	1	9	0
	D4034-043	1	9	0
	D4672-1	2	24	0
	M304EX0.75-16F	33	2,179	0
150-HandFinish	AN3-10A	6	301	0
	D2931	2	958	0
	D4021-5	2	46	0
	MS20600-AD4W3	2	357	0
	MS21042L3	6	3,308	0
	NAS1149F0332P	12	3,621	0

066225

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE

DISPOSITION

Re

Use

Suspected Unappr

Description Work Order Deviation

QC / QA Coordinator
Approval

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I